

Work Order ID 67288

Tuesday, March 15, 2011 8:13:12 AM



Page 1

Item ID: D2521

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw 205

Start Date: 3/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

12-03-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2521	Rev J

60

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2521 blank file

B11-3-23



130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2521 Identify as D2521
3-Deburr

and 11/04/26

8

8

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

and 11/04/26

8

8

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

SL 11/04/28



QC

Memo

0.00

Quality Control

(8)

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PPP 67290

60 11/4/28 (8)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28 JF

MF
11-04-28

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Picklist Print

Tuesday, March 15, 2011 8:13:18 AM

Page 1

Work Order ID: 67288

Parent Item: D2521

Parent Item Name: Bearpaw 205





Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No				sf	257.1000		58.94737			
UHMW 1" Black													

B11-3-23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	257.1	
115955	38.8	
116554	108.3	
116796	12	
116797	98	

116797

8

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DART AEROSPACE LTD		Work Order:	67288
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	—		Vern ML-7	
B	0.90	0.96	.930	—		"	
C	0.27	0.330	.296	—		"	
D	0.470	0.530	.500	—		"	
E	21.740	21.760	21.750	—		M-type ML-2	
F	0.72	0.780	.750	—		Vern ML-7	
G	0.35	0.410	.378	—		"	
H	11.490	11.570	11.500	—		M-type ML-2	
I	3.41	3.47	3.425	—		Vern ML-7	
J	11.790	11.810	11.800	—		M-type ML-2	
K	9.47	9.53	9.500	—		"	
L	7.190	7.210	7.200	—		"	
M	6.910	6.970	6.940	—		"	
N	44.47	44.530	44.500	—		"	
O	6.590	6.650	6.625	—		"	
P	0.940	0.980	.965	—		Vern ML-7	
Q	18.97	19.03	19.000	—		M-type ML-2	
R	0.350	0.410	.380	—		Vern ML-7	
S	0.740	0.780	.765	—		"	
T	0.240	0.280	.252	—		"	
U	0.370	0.410	.390	—		"	
V	0.740	0.780	.745	—		"	
W	0.740	0.780	.765	—		"	

Measured by:	mf	Audited by:	J	Prototype Approval:	N/A
Date:	11/04/26	Date:	11/04/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

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DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 48.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62288

P/11-08-18

RELEASED

06 08.23 [Signature]

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Dart Aerospace Ltd

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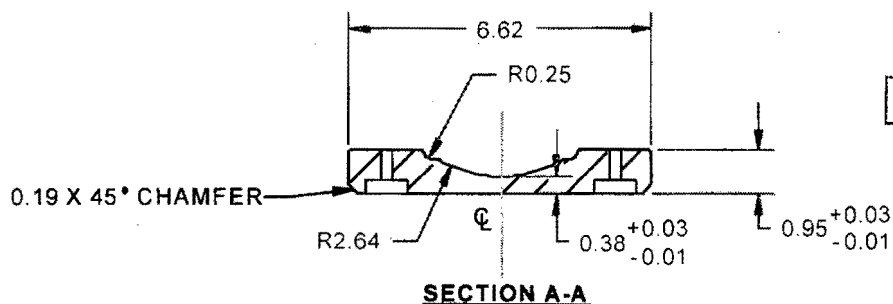
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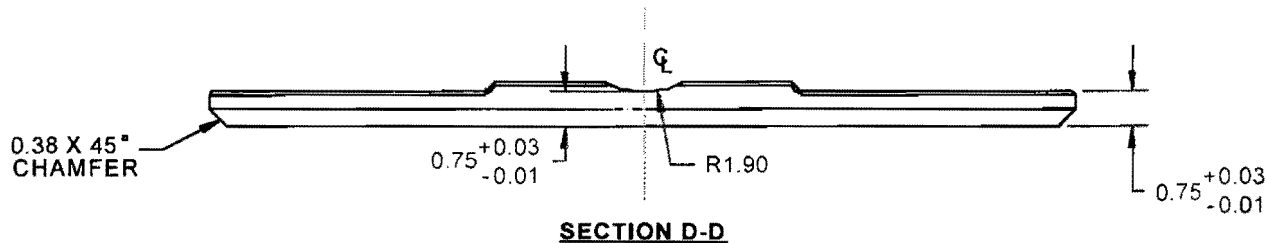
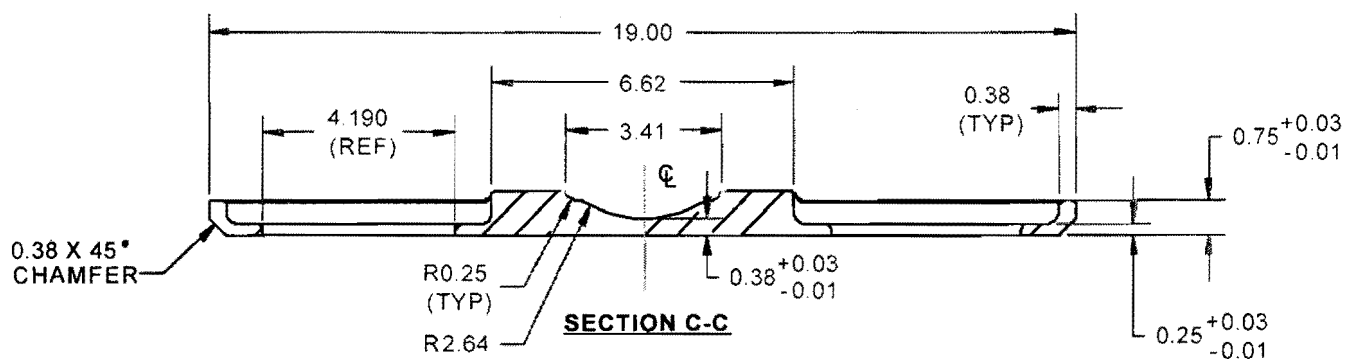
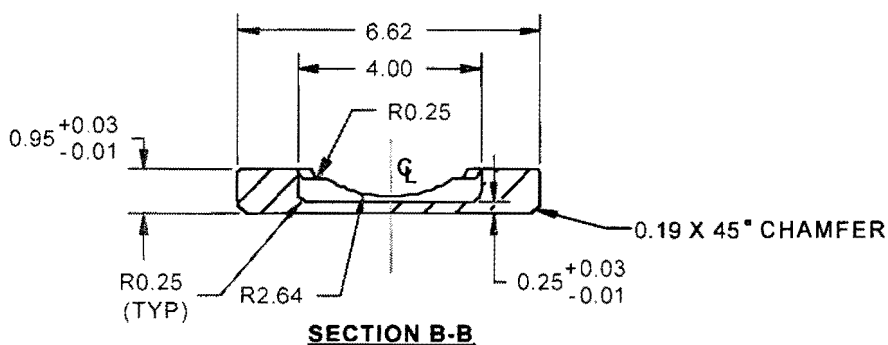
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



RELEASED

06.28.23

W/6 97288



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